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D4463-041
Job Sheet 184220



Part No: D4463-041

Job Qty: 3 ea

Part Name: Tank Top Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,2 IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER
DWG REV.B DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	3 pcs		11/2/18	0.01	1.19	Waterjet 1		<i>SC 18/10/18</i>
110	QC	3 pcs		11/2/18	0.00	0.00	QC2 Waterjet-3		<i>SC 18/10/18</i>
120	QC	3 pcs		11/2/18	0.00	0.00	QC8-4		<i>OCT 29 2018 68</i>
130	Small Fab	3 pcs		11/2/18	0.00	1.13	Small Fab-6		<i>9-89</i>
140	QC	3 pcs		11/2/18	0.00	0.00	QC5		<i>NOV 15 2018 68</i>
150	HandFinish	3 pcs		11/2/18	0.00	0.48	HandFinish1		<i>D.R. 18/11/18</i>
160	QC	3 pcs		11/2/18	0.00	0.00	QC7-3		<i>SC</i>
170	Small Fab	3 pcs		11/2/18	0.00	1.13	Small Fab-6		<i>SC DAS</i>
180	QC	3 pcs		11/2/18	0.00	0.00	QC5		<i>NOV 15 2018 68</i>
190	Packaging	3 pcs		11/2/18	0.00	0.00	Packaging3-2		<i>CPL 9-89</i>
200	QC21-SA	3 Ea		11/2/18	0.00	0.00	QC21		<i>DAS 21 NOV 20 2018 9-89</i>

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	11.5920 sf (3.864 ea)	100-Waterjet	
MS20426AD3-4	Rivet	144 Ea (48 ea)	170-Small Fab	<i>FM136444-2</i>
NAS1473R3	Anchor Nut	72 Ea (24 ea)	170-Small Fab	<i>FM137710-44 36x</i> <i>5119245 (36x)</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.063	12	206	0
170-Small Fab	MS20426AD3-4	144	4,584	0
	NAS1473R3	72	88	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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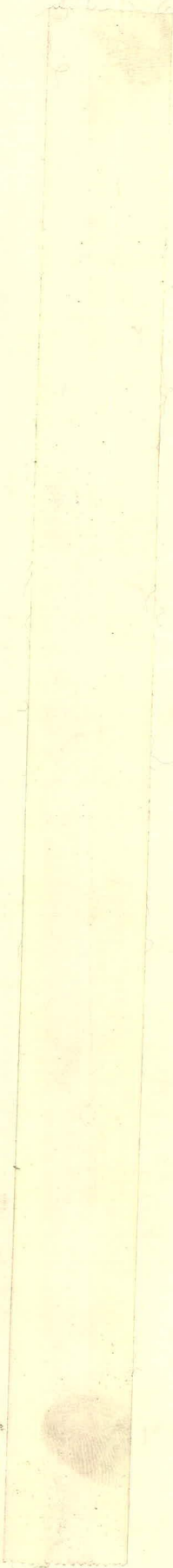
Description Work Order Deviation	Disposition	Part: D4463-041 Job No: 184220 Serial No/Batch: S122075 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 10/28/18	By _____ Supervisor Trification
			Coordinator val

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Force ☐ Bending ☐ Centre Not Con ☐ Cracks ☐ Crimp/Kink/Rip ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
		Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐	Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____			

DART AEROSPACE LTD		Work Order:	184220
Description: Tank Top		Part Number:	D4463-1
Inspection Dwg: D4463	Rev: D	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0.099				
Ø0.206	+0.005/-0.001	Ø0.208				
Ø1.00	+0.012/-0.001	Ø1.002				
1.15	+/-0.030	1.154				
1.85	+/-0.030	1.853				
2.20	+/-0.030	2.204				
2.30	+/-0.030	2.305				
5.29	+/-0.030	5.30				
8.30	+/-0.030	8.30				
8.93	+/-0.030	8.94				
8.98	+/-0.030	8.988				
9.31	+/-0.030	9.317				
10.42	+/-0.030	10.42				
11.26	+/-0.030	11.26				
1.61	+/-0.030	1.614				
1.68	+/-0.030	1.687				
1.82	+/-0.030	1.826				
3.41	+/-0.030	3.411				
3.79	+/-0.030	3.80				
6.43	+/-0.030	6.44				
7.36	+/-0.030	7.366				
7.80	+/-0.030	7.80				
10.75	+/-0.030	10.75				
11.38	+/-0.030	11.38				
11.80	+/-0.030	11.80				
13.27	+/-0.030	13.27				
1.15	+/-0.030	1.155				
3.00	+/-0.030	3.023				
3.26	+/-0.030	3.265				
7.00	+/-0.030	7.002				
10.74	+/-0.030	10.74				
11.00	+/-0.030	11.00				
11.63	+/-0.030	11.63				
15.29	+/-0.030	15.29				
15.48	+/-0.030	15.48				
19.48	+/-0.030	19.48				
23.48	+/-0.030	23.48				
23.67	+/-0.030	23.67				
24.11	+/-0.030	24.11				
27.46	+/-0.030	27.46				



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OCT 5 2018